

Work Order ID 85141

June-04-12 1:26:47 PM

\*85141\*

Page 1

Item ID: D350-636-012

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Skidtube RH

Start Date: 04/06/2012 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 18/06/2012 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/07 Tooling:

Date:

Run Start \*NR1\*

QC:

Date: SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2750	F								
D3492	C								

MLJ 12/07/13

100

0.00

\*100\*

DOCUMENT CONTROL

DC

0.00

Memo

2008 5/17/12

Document Control

Photocopy blue file and type labels per PPP D350-636-012 CHG 006

JB

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

# Work Order ID 85141

**\*85141\***

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Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

110

0.00

**\*110\***

Skidtubes

Skidtubes

Skidtubes

Memo

1- Pick D2600-3 Bent

2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D2750

3- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500", deburr.

4- Locate DT8329 off of blade fitting bolt holes and drill pilot holes for blade fitting

5- Drill only two fwd step holes using DT9616. Ensure proper positioning.

6- Drill pilot holes as per Dwg D2750 sheet 4 (D2750-2 details). Drill using drill Jig DT8150 & DT8863A for first side only DT8863B for second side (detail K)

7- Clecko DT8863B on second side of tube and drill pilot holes for detail B. \*\*\*SECOND SIDE\*\*\*

8-Open up holes for Detail "K" to 0.375" (4 holes per side) and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750. Open up holes for ground handling and detail L to 0.500" (8 holes per side)

9-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".

10-Open up holes of Detail A to 0.297" (total of 2 holes per side)

BE 12/06/25

BE 12/06/25

SAD 12-06-28

BE 12/06/25

SAD 12-06-28

BB 12/06/28

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Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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11-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left  
from bending as per QSI 004A/R Aluminum Rod batch: M122130

12-Grind welds flush as per Dwg D2750

*7 BE 12/06/25*

120

QC10- Inspect visual per QSI004- ground welds

0.00

**\*120\****8 12/06/25*

QC

Memo

0.00

Quality Control

130

QC5- Inspect part completeness to step on W/O

0.00

**\*130\****8 12/06/25*

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
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Process Plan:

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Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

140

Chemical Conversion Coat per QSI005 4.1

0.00

**\*140\***

HandFinish

Memo

0.00

Hand Finishing

1 76 12 73

150

QC7-Inspect Chemical Conversion Coat

0.00

**\*150\***

QC

Memo

0.00

Quality Control

① 500 12 02 03

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QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

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--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160

0.00

**\*160\***

Skidtubes

Skidtubes

Memo

0.00

1-Open up holes of Detail L and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.

2-Open up holes of Detail K to 0.750" (total of 4 holes per side) as per dwg D2750.

3-Open float holes to .500" (4 per Side)

4-Chamfer holes of Detail K, L, ground handling and float holes per dwg D2750 (welding instructions on sheet 9)

5-Deburr and blow out all chips from inside of tube

6-Prepare tube for welding, remove alodine as required.

7-Bond web D2739 in place as per QSI 015

A/R Sikaflex-291 batch: 121409  
exp. date: 8-4-12

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 &amp; QSI004 (welding instructions on sheet 9)

A/R Aluminum Rod batch: M122130

9- At section AP-AP drill out x-bolt spacer to 0.404"

10-Grind welds flush as per Dwg D2750

11-Spot face ground handling holes section (total of 4 places per side) as per

SAD 12-07-03

-DC 12/07/03

7BE 12/07/05

8E 12/07/06

W/O:		WORK ORDER CHANGES					
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Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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dwg D2750

12-Deburr holes

*BE 12/07/06*

170

QC10- Inspect visual per QSI004- ground welds

0.00

**\*170\***

QC

Memo

0.00

*5/17/09*

Quality Control

180

QC5- Inspect part completeness to step on W/O

0.00

**\*180\***

QC

Memo

0.00

*5/17/09*

Quality Control

W/O:		WORK ORDER CHANGES					
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Start Date: 04/06/2012 Start Qty: 1.00

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Required Date: 18/06/2012 Req'd Qty: 1.00

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Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

190

Pressure Wash per QSI005 4.3

0.00

**\*190\***

HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

1 7/6 1279

200

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

**\*200\***

Powdercoat

Memo

0.00

Powder Coating

START TIME: 9:30

OVEN TEMPERATURE: 320°F

FINISH TIME: 10:00

1X Ø ML 12/07/09

210

QC3- Inspect Part Finish

0.00

**\*210\***

QC

Memo

0.00

Quality Control

Inspect for foreign object per QSI 024

174 d JU 12/07/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**Work Order ID 85141****\*85141\***

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Run Start **\*NR1\***

QC: Date: SPC (Y/N): Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230	HandFinishing	0.00							
<b>*230*</b>									
HandFinish	Memo	0.00							
Hand Finishing	1-Install inserts as per dwg D2750								
	2-Inspect for Foreign Objects								
	3-Spray inside of tube with "LPS-3" batch: <u>NVA</u>								
	4-Install blade fitting D3488-042, wearshoes and ground handling hardware as per dwg D2750 SIKA FLEX 241 BATCH: <u>11121409</u> EXP DATE: <u>12/05</u>								
	5-assemble o'ring to plug as per dwg D3492 and apply o'ring lube A/R 55-o'ring lube batch: <u>11118348</u>								
	6-Coat all exposed fasteners with "LPS Procyon" batch: <u>1111596</u>								

1 RH of 11/07/10

W/O:		WORK ORDER CHANGES					
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**\*85141\***

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Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
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Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

240

QC5- Inspect part completeness to step on W/O

0.00

**\*240\***

QC

Memo

0.00

*5/12/11*

Quality Control

250

Pick Kit

0.00


**\*250\***

Packaging

Memo

0.00

Packaging

*6/27/11* 

260

QC4- 100% Inspect kits for completeness

0.00

**\*260\***

QC

Memo

0.00

**DAS**  
**16**  
**2-83** *12/12/12*

Quality Control

W/O:		WORK ORDER CHANGES					
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Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

270

0.00

**\*270\***

Packaging

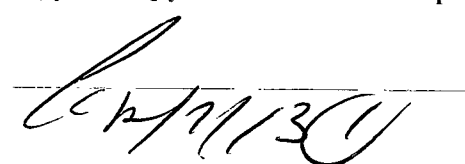
Packaging

Memo

0.00

Packaging

Package as per PPP D350-636-012



280

0.00

**\*280\***

QC21- Final Inspection - Work Order Release

QC

Memo

0.00

Quality Control

MLJ 12/07/13

MLJ 12/09/13

W/O:		WORK ORDER CHANGES					
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# Picklist Print

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Page 1

Work Order ID: 85141

\*85141\*

Parent Item: D350-636-012

\*D350-636-012\*

Parent Item Name: Skidtube RH

Start Date: 04/06/2012

Required Date: 18/06/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:102.09.25Rearranged procedure stepsKJ  
 IPP Rev:J 06-03-29 As per Rev D EC  
 IPP Rev:K 06-07-13 As per dsi9343 EC  
 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC  
 IPP Rev:M 08-04-22 update steps 4,13 DD verified by:EC  
 IPP Rev:N 08-09-23 revF as per dwg DD verified by:ec IPP Rev:O  
 10.06.22 revise seq110 DD verf:EC IPP Rev:P 10.10.01 as  
 per IIN revH DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2600-3-BENT		Manufactured	No			110	Each	29.0000	1	1			

\*D2600-3-BENT\*

Extrusion Bent

\*\*

8/12/06/25

Location	Loc Qty	Loc Code
LG	29	
66875	7	
73253	1	
75021	1	
75022	1	
75023	1	
81330	4	
83305	1	
83442	13	

D2744

Manufactured No

110

Each

35.0000

1

1

\*D2744\*

Cap

\*\*

8/12/06/25

Location	Loc Qty	Loc Code
LG002	35	
62715	1	
78900	3	
83412	31	

W/O:		WORK ORDER CHANGES					
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\*85141\*

\*D350-636-012\*

Start Date: 04/06/2012

Required Date: 18/06/2012

Start Qty: 1.00

Required Qty: 1.00

D2739

Manufactured No

160

Each

13.0000

1

1

\*D2739\*

\*\*

DL 12/08/03

350 I Beam

Location

B85486

Loc Qty

Loc Code

LG

13

72155

1

81508

1

83447

4

83448

5

83548

2

①

D2743

Manufactured No

160

Each

296.0000

8

8

\*D2743\*

\*\*

BE 12/07/05

Crossbolt Spacer

Location

Loc Qty

Loc Code

LG

222

81965

55

83262

167

LG001

74

67766

4

68251

3

73403

64

74445

1

79517

2

8

D3490-3

Manufactured No

160

Each

46.0000

4

4

\*D3490-3\*

\*\*

BE 12/07/05

Cross Bolt Spacer

Location

Loc Qty

Loc Code

LG001

46

83313

46

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

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Page 3

Work Order ID: 85141

Parent Item: D350-636-012

Parent Item Name: Skidtube:RH

\*85141\*

\*D350-636-012\*

Start Date: 04/06/2012

Required Date: 18/06/2012

Start Qty: 1.00

Required Qty: 1.00

D3490-1

Manufactured No

160

Each

45.0000

4

4

\*D3490-1\*

Cross Bolt Spacer

\*\*

BE 12/07/05  
B 85419 v4

Location

Loc Qty

Loc Code

LG

2

81976

2

LG001

43

62450

2

74875

4

77042

3

83269

34

D3631-1

Manufactured No

230

Each

347.0000

8

8

\*D3631-1\*

Washer

\*\*

sl 12/07/10

Location

Loc Qty

Loc Code

FG

332

81874

2

83588

330

ST072

15

68062

2

75548

13

D3791-1

Manufactured No

230

Each

17.0000

i

1

\*D3791-1\*

Wearplate

\*\*

sl 12/07/10

Location

Loc Qty

Loc Code

FP002

17

62239

2

83392

15

x(

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Page 4

Work Order ID: 85141

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

\*85141\*

\*D350-636-012\*

Start Date: 04/06/2012

Required Date: 18/06/2012

Start Qty: 1.00

Required Qty: 1.00

D3793-3

Manufactured No

230

Each

28.0000

1

1

\*D3793-3\*

Wearshoe

\*\*

HL 12/07/10

Location

Loc Qty

Loc Code

FP001

28

83394

16

83901

12

XL

MS21043-6

Purchased No

230

Each

618.0000

4

4

\*MS21043-6\*

NUT

\*\*

HL 12/07/10

Location

Loc Qty

Loc Code

FG

20

103693

20

ST301

598

117887

2

118384

96

120308

500

XL

D3794-1

Manufactured No

230

Each

26.0000

1

1

\*D3794-1\*

Gasket

\*\*

HL 12/07/10

Location

Loc Qty

Loc Code

FP

6

82167

6

FP002

20

83395

20

XL

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 85141

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

\*85141\*

\*D350-636-012\*

Start Date: 04/06/2012

Required Date: 18/06/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1611-010

Purchased

No

230

Each

188.0000

8

8

\*\*

yu

u/07/10

\*NAS1611-010\*

O-RING

Location

Loc Qty

Loc Code

FP001

188

110915

14

117460

8

118077

1

118612

3

119438

47

121259

2

121415

4

121584

59

121723

50

vg

D2741

Manufactured

No

250

Each

20.0000

1

1

\*\*

831358 JB 12/07/11

\*D2741\*

Blade, 350 Skidtube

Location

Loc Qty

Loc Code

ST

-10

ST466

30

71856

1

79516

19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 85141

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

\*85141\*

\*D350-636-012\*

Start Date: 04/06/2012

Required Date: 18/06/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1515H3L

Purchased

No

230

Each

146.0000

4

4

**\*NAS1515H3I \***

WASHER

?

\*\*

12/07/10

Location

Loc Qty

Loc Code

FG

40

102472

40

ST277

106

118686

3

119438

1

120360

11

121243

2

121556

89

X4

NAS1611-013

Purchased

No

230

Each

361.0000

8

8

**\*NAS1611-013\***

O-RING

\*\*

12/07/16

Location

Loc Qty

Loc Code

FP001

361

116582

5

117291

2

117887

53

119623

36

121584

15

121825

200

121826

50

X2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



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Work Order ID: 85141

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

\*85141\*

\*D350-636-012\*

Start Date: 04/06/2012

Required Date: 18/06/2012

Start Qty: 1.00

Required Qty: 1.00

AN3C6A

Purchased

No

230

Each

451.0000

4

4

\*AN3C6A\*

BOLT

\*\*

12/07/10

Location

Loc Qty

Loc Code

FP001

1

111982

1

ST351

450

111982

2

116419

23

116549

2

116704

12

117619

10

117688

1

117872

5

118422

13

119449

21

120423

3

120693

158

121682

200

84

NAS1149C0832R

Purchased

No

230

Each

257.0000

1

1

\*NAS1149C0832R\*

WASHER

\*\*

12/07/10

Location

Loc Qty

Loc Code

ST297

257

114915

257

21

D3536-25

Manufactured

No

230

Each

28.0000

1

1

\*D3536-25\*

Gasket

\*\*

12/07/10

Location

Loc Qty

Loc Code

FP

28

83391

12

83900

16

21

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Work Order ID: 85141

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

\*85141\*

\*D350-636-012\*

Start Date: 04/06/2012

Required Date: 18/06/2012

Start Qty: 1.00

Required Qty: 1.00

D3794-3

Manufactured No

230

Each

23.0000

1

1

\*D3794-3\*

Gasket

\*\*

u nlog10

Location

Loc Qty

Loc Code

FP

21

83396

21

x1

FP002

2

74530

2

Purchased

No

230

Each

1,302.000

34

34

AN3C5A

\*AN3C5A\*

Bolt

\*\*

u nlog10

Location

Loc Qty

Loc Code

FP001

7

115835

7

ST350

1295

116419

28

117343

13

117764

7

117872

2

119749

23

120423

28

121068

12

121255

500

121444

182

121708

500

x34

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 85141

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

\*85141\*

\*D350-636-012\*

Start Date: 04/06/2012

Required Date: 18/06/2012

Start Qty: 1.00

Required Qty: 1.00

D3537-1

Manufactured No

230

Each

83.0000

3

3

\*D3537-1\*

Wearpad

\*\*

12/07/10

## Location

## Loc Qty

## Loc Code

FG

10

B83256

13

79833

10

FP002

73

69817

5

81360

14

81362

19

83254

1

83255

3

84091

31

D3535-25

Manufactured No

230

Each

34.0000

1

1

\*D3535-25\*

Wearshoe

\*\*

12/07/10

## Location

## Loc Qty

## Loc Code

FP001

34

62233

1

81357

1

82156

2

83387

17

83899

13

B83899

11

D3492-3

Manufactured No

230

Each

167.0000

8

8

\*D3492-3\*

Plug

\*\*

12/07/10

## Location

## Loc Qty

## Loc Code

FP-A

167

81967

5

83099

40

83529

122

10

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Shop Packet Print

Page 9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Page 10

Work Order ID: 85141

\*85141\*

Parent Item: D350-636-012

\*D350-636-012\*

Parent Item Name: Skidtube RH

Start Date: 04/06/2012

Required Date: 18/06/2012

Start Qty: 1.00

Required Qty: 1.00

AN960C10L NAS1149C0332 Purchased No

230 Each 0.0000 38 38

\*AN960C10I \*✕

washer

D3488-042

Manufactured No

230 Each 9.0000 1 1

\*D3488-042\*

Blade Fitting Assembly, RH

\*\*

## Location

## Loc Qty

## Loc Code

FP002

9

1383417

62003

1

77015

1

82258

7

ALS4-1032-225

Purchased No

230 Each 781.0000 38 38

\*AI S4-1032-225\*

Insert

\*\*

## Location

## Loc Qty

## Loc Code

ST281

758

108696

146

110768

62

118386

55

118966

68

121269

427

ST282

23

120410

10

120451

13

1112240

130

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



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Work Order ID: 85141

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

\*85141\*

\*D350-636-012\*

Start Date: 04/06/2012

Required Date: 18/06/2012

Start Qty: 1.00

Required Qty: 1.00

D3492-1

Manufactured No

230

Each

257.0000

8

8

\*D3492-1\*

Plug

\*\*

u 12/07/12

Location

Loc Qty

Loc Code

FP002

242

69531

8

74444

2

76235

4

83259

228

FP-A

15

83098

15

x 8

D3793-1

Manufactured No

230

Each

28.0000

1

1

\*D3793-1\*

Wearshoe

\*\*

u 12/07/12

Location

Loc Qty

Loc Code

FP001

28

82171

2

83393

13

83903

13

x 1

AN8C35A

Purchased No

230

Each

68.0000

1

1

\*AN8C35A\*

BOLT

\*\*

u 12/07/12

Location

Loc Qty

Loc Code

FP002

67

115960

1

118286

16

121275

50

ST346

1

114442

0

115188

0

115960

1

x 1

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Page 12

Work Order ID: 85141

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

\*85141\*

\*D350-636-012\*

Start Date: 04/06/2012

Required Date: 18/06/2012

Start Qty: 1.00

Required Qty: 1.00

MS21083C8

Purchased

No

230

Each

81.0000

1

1

\*MS21083C8\*

NUT

\*\*

21/07/10

## Location

## Loc Qty

## Loc Code

304

75

121185

29

121349

46

FP002

1

115884

1

ST303

4

115884

0

118077

1

119309

2

119638

1

ST304

1

121524

1

D2745

Manufactured

No

230

Each

122.0000

8

8

\*D2745\*

Bushing

\*\*

21/07/10

## Location

## Loc Qty

## Loc Code

FP

6

79518

6

FP001

116

69529

1

76142

1

83260

114

28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Page 13

Work Order ID: 85141

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

\*85141\*

\*D350-636-012\*

Start Date: 04/06/2012

Required Date: 18/06/2012

Start Qty: 1.00

Required Qty: 1.00

AN6C44A

Purchased

No

230

Each

86.0000

4

4

**\*AN6C44A\***

BOLT

\*\*

u 12/07/10

Location

Loc Qty

Loc Code

FG

2

103964

2

ST343

84

121013

11

121167

13

121440

50

121689

10

XU

D3532-1

Manufactured

No

250

Each

7.0000

2

2

**\*D3532-1\***

Spacer

\*\*

83319 213 12/07/11

Location

Loc Qty

Loc Code

ST053

7

82041

7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 85141

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

\*85141\*

\*D350-636-012\*

Start Date: 04/06/2012

Required Date: 18/06/2012

Start Qty: 1.00

Required Qty: 1.00

MS21083C8

Purchased

No

250

Each

81.0000

2

2

\*\*

\*MS21083C8\*

NUT

JB SP

Location

Loc Qty

Loc Code

304

75

121185

29

121349

46

121349

FP002

1

115884

1

ST303

4

115884

0

118077

1

119309

2

119638

1

ST304

1

121524

1

NAS1149D0863J

Purchased

No

250

Each

251.0000

2

2

\*\*

\*NAS1149D0863.J\*

WASHER

JB SP 12/07/11

Location

Loc Qty

Loc Code

ST298

251

118078

34

119307

17

120308

100

121556

100

120308

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



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Work Order ID: 85141

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

\*85141\*

\*D350-636-012\*

Start Date: 04/06/2012

Required Date: 18/06/2012

Start Qty: 1.00

Required Qty: 1.00

D3493-1

Manufactured No

250

Each

127.0000

2

2

\*\*

S \*D3493-1\*  
Washer

JB

Location

Loc Qty

Loc Code

ST050

127

77573

1

82023

26

83097

100

83097

AN8C21A

Purchased

No

250

Each

57.0000

2

2

\*\*

S \*AN8C21A\*  
BOLT

JB

12/07/11

Location

Loc Qty

Loc Code

ST343

57

118758

3

121167

4

121275

50

121275

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

# GENERAL NOTES:

- 1) MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- 2) FINISH:  
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.  
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- 8) WELD PER DART QSI 004
- 9) INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ( $\phi 0.297$ ) FOR WEARSHOE INSERTS
- 10) FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:  
MINIMUM YIELD TENSILE STRENGTH = 35 KSI  
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- 11) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.  
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF  
POWDER COATING WITH MEK DEGREASER
- 12) SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- 13) SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

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NO. 85141 MJS  
12/06/04

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6-9-04

F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/3 REPLACES D3535-13/35 (ZN C8-1); D3794-1/3 REPLACES D3536-13/35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS, CHANGE INSERTS, ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741; QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	PC		
DRAWN	PC		
CHECKED	PC		
MFG. APPR.	PC		
APPROVED	PC		
DE APPR.	PC		
DATE	08.07.16		

DART AEROSPACE USA, INC.  
PORT HADLOCK, WA

DRAWING NO. D2750  
REV. F  
SHEET 1 OF 11  
TITLE 350 SKIDTUBE ASSEMBLY  
SCALE NTS

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

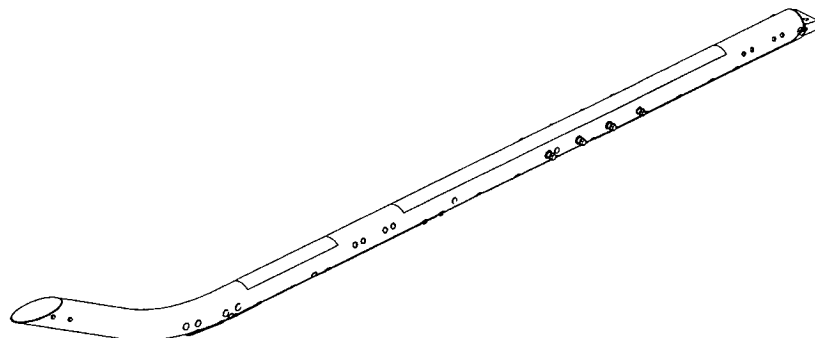
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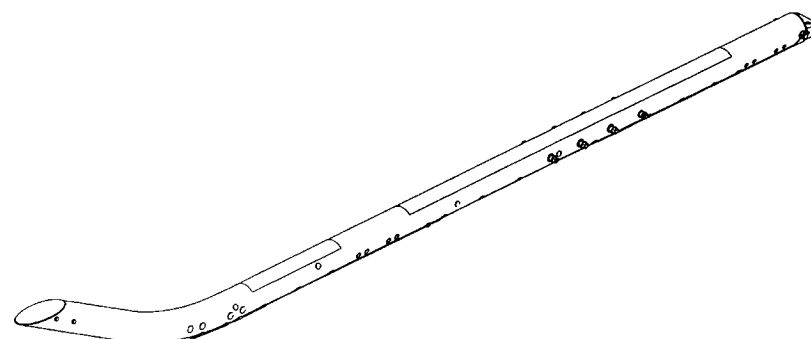
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

05141



D2750-041 350 SKIDTUBE ASSEMBLY, LH



D2750-042 350 SKIDTUBE ASSEMBLY, RH

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DRAWN	AA	PORT HADLOCK, WA	
CHECKED	A	DRAWING NO.	REV. F
MFG. APPR.	MA	<b>D2750</b>	SHEET 2 OF 11
APPROVED	ME	TITLE	SCALE
DE APPR.	MA	<b>350 SKIDTUBE ASSEMBLY</b>	NTS
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**Dart Aerospace Ltd**

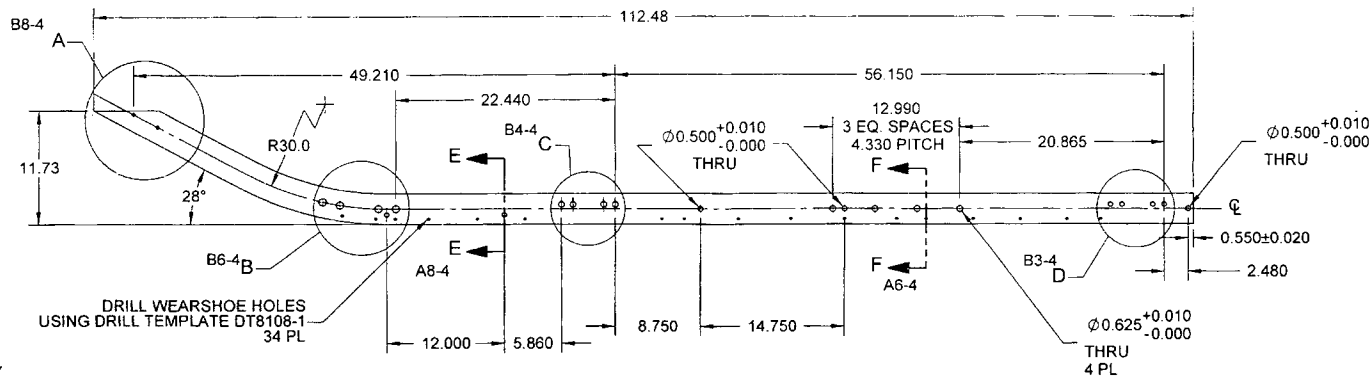
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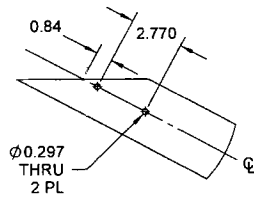
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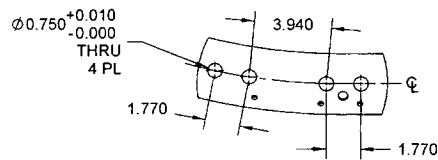
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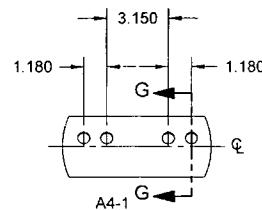
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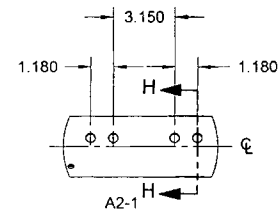
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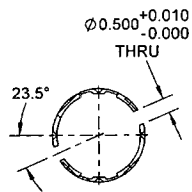
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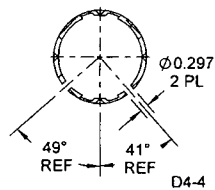
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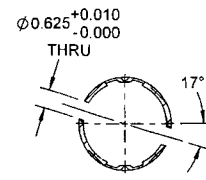
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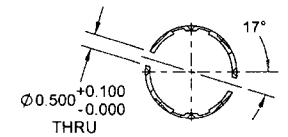
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SCALE 3X, 2 PL



**SECTION F-F**  
SCALE 3X, 17 PL



**SECTION G-G**  
SCALE 3X, 4 PL



**SECTION H-H**  
SCALE 3X, 4 PL

DESIGN	IPB
DRAWN	IPB
CHECKED	
MFG. APPR.	
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DE APPR.	
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<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA	
DRAWING NO. <b>D2750</b>	REV. F SHEET 4 OF 11
TITLE <b>350 SKIDTUBE ASSEMBLY</b>	SCALE NTS
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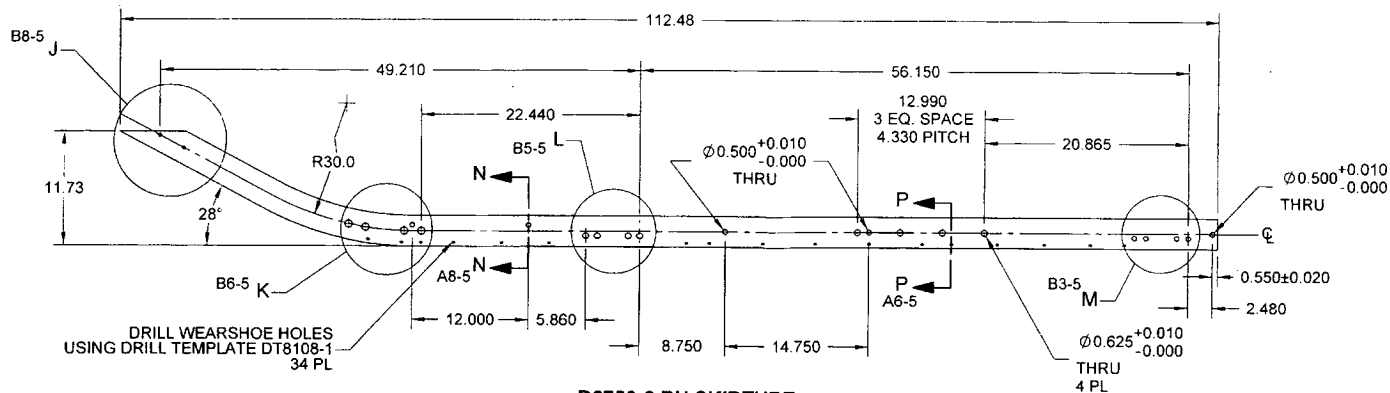
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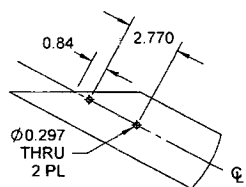
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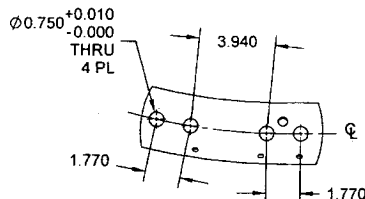




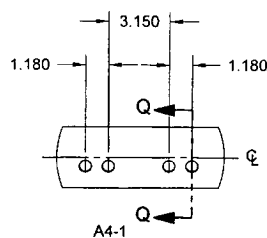
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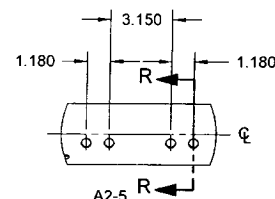
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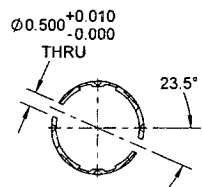
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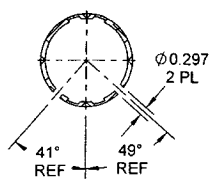
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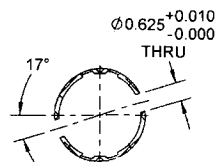
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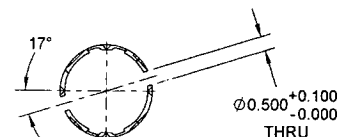
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SCALE 3X, 2 PL



**SECTION P-P**  
SCALE 3X, 17 PL



**SECTION Q-Q**  
SCALE 3X, 4 PL



**SECTION R-R**  
SCALE 3X, 4 PL

DESIGN	PEL	<b>DART AEROSPACE USA, INC.</b>	
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MFG. APPR.		<b>D2750</b>	SHEET 5 OF 11
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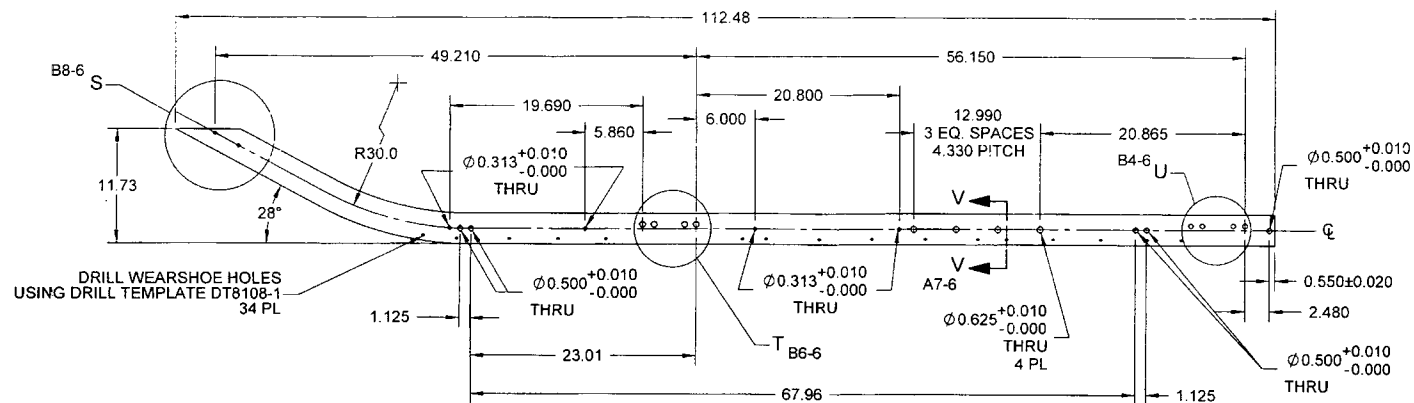
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

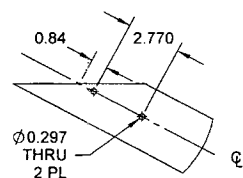
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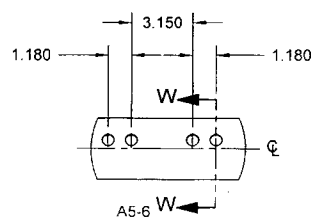
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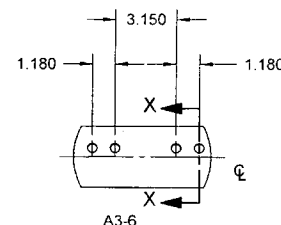
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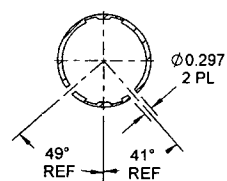
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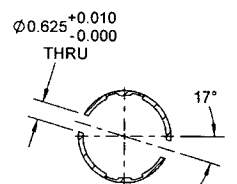
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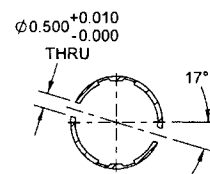
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**SECTION V-V**  
SCALE 3X, 17 PL



**SECTION W-W**  
SCALE 3X, 4 PL



**SECTION X-X**  
SCALE 3X, 4 PL

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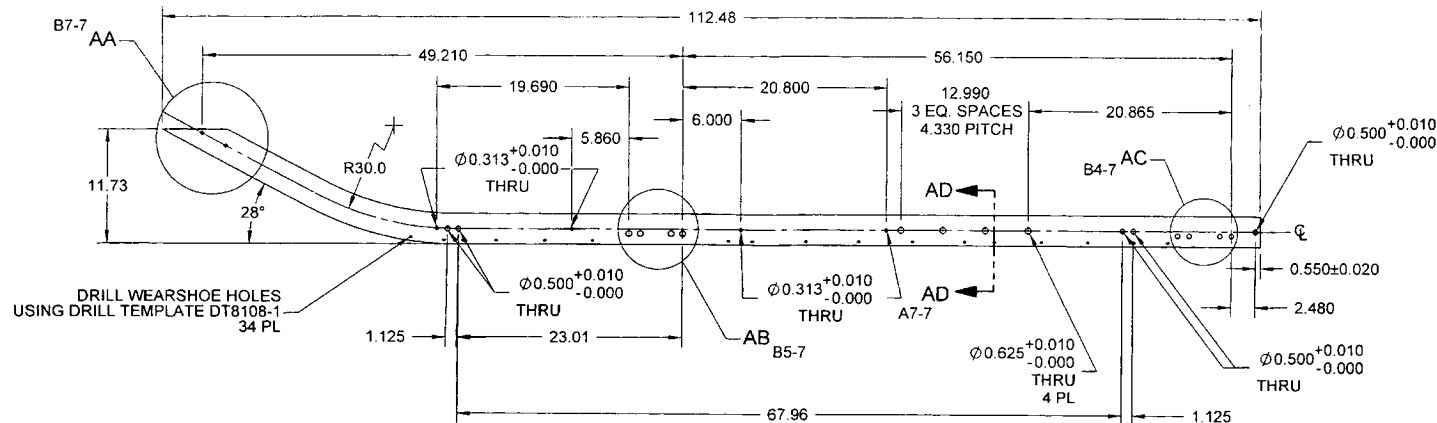
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

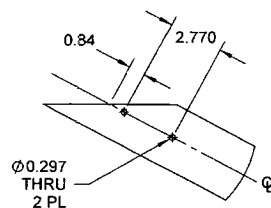
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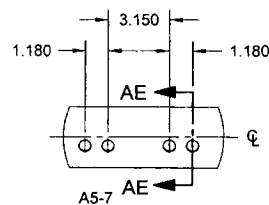
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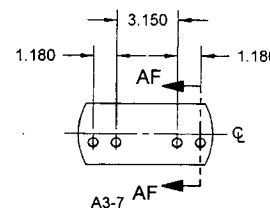
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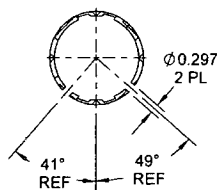
**DETAIL AA**  
SCALE 2X  
D7-7



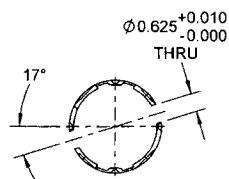
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A5-7 AE



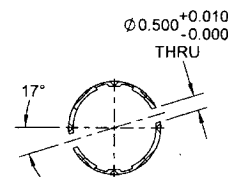
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SCALE 2X  
D3-7  
A3-7 AF



**SECTION AD-AD**  
SCALE 3X, 17 PL  
D3-7



**SECTION AE-AE**  
SCALE 3X, 4 PL  
B6-7



**SECTION AF-AF**  
SCALE 3X, 4 PL  
B4-7

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



## WORK ORDER CHANGES

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

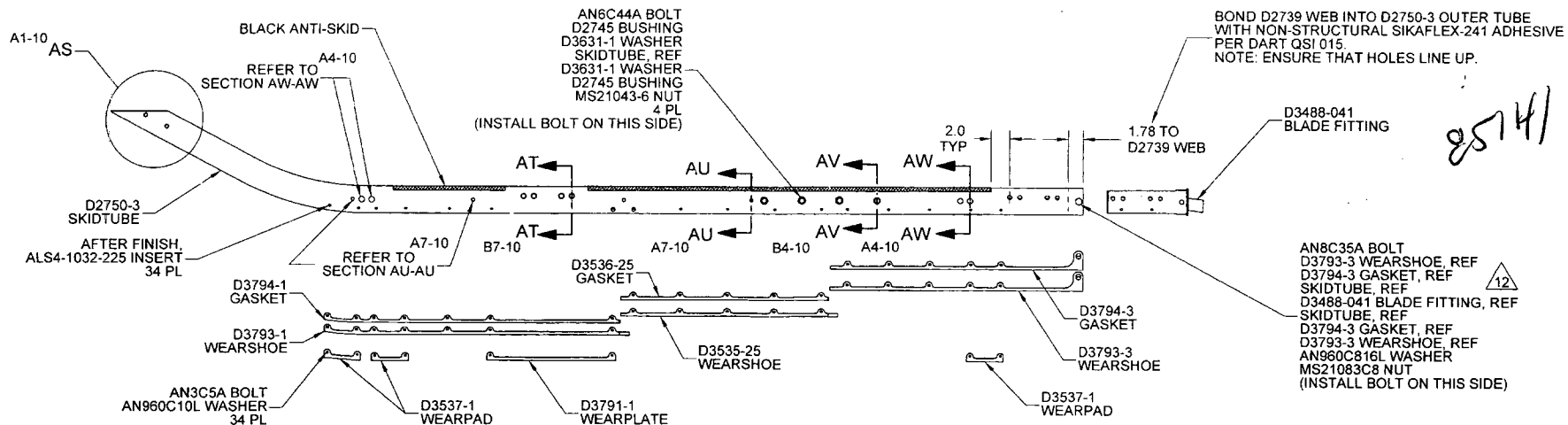
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

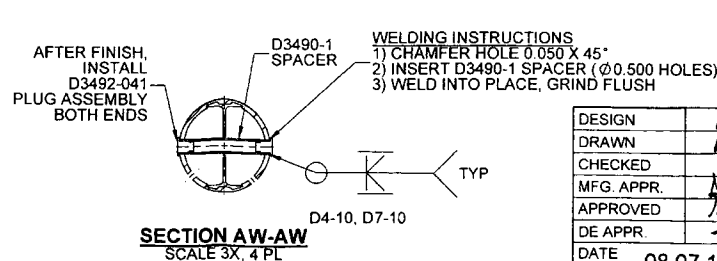
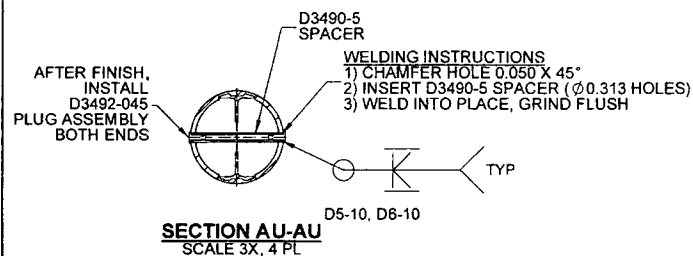
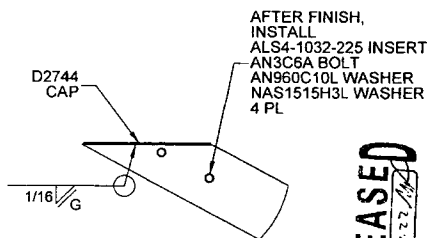
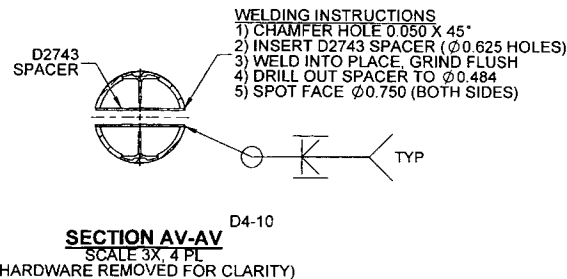
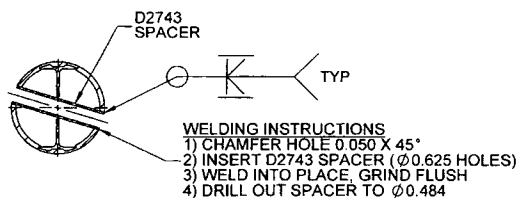
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





### D2750-043 350 SKIDTUBE ASSEMBLY, LH



DESIGN		<b>DART AEROSPACE USA, INC.</b>	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		<b>D2750</b>	SHEET 10 OF 11
APPROVED		TITLE	SCALE
DE APPR.		<b>350 SKIDTUBE ASSEMBLY</b>	NTS
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**RELEASED**  
2018-08-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

A1-11

BA

BLACK ANTI-SKID

REFER TO  
SECTION BE-BE

A4-11

(INSTALL NUT ON THIS SIDE)

BB

BC

BD

BE

2.0  
TYP1.78 TO  
D2739 WEBBOND D2739 WEB INTO D2750-4 OUTER TUBE  
WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE  
PER DART QSI 015.  
NOTE: ENSURE THAT HOLES LINE UP.D3488-042  
BLADE FITTINGD2750-4  
SKIDTUBEAFTER FINISH  
ALS4-1032-225 INSERT  
34 PLREFER TO  
SECTION BC-BC

A7-11

BB

BC

BD

BE

D3536-25  
GASKET

A7-11

B4-11

A4-11

D3794-3  
GASKETD3794-3  
GASKETD3794-3  
WEARSHOED3794-3  
WEARSHOED3537-1  
WEARPADD3793-1  
WEARSHOEAN3C5A BOLT  
AN960C10L WASHER  
34 PLD3537-1  
WEARPADD3791-1  
WEARPLATED3535-25  
WEARSHOED3537-1  
WEARPADAN8C35A BOLT  
D3793-3 WEARSHOE, REF  
D3794-3 GASKET, REF  
SKIDTUBE, REF  
D3488-042 BLADE FITTING, REF  
SKIDTUBE, REF  
D3794-3 GASKET, REF  
D3793-3 WEARSHOE, REF  
AN960C816L WASHER  
MS21083C8 NUT  
(INSTALL NUT ON THIS SIDE)**D2750-044 350 SKIDTUBE ASSEMBLY, RH**D2743  
SPACER

TYP

WELDING INSTRUCTIONS  
1) CHAMFER HOLE 0.050 X 45°  
2) INSERT D2743 SPACER (Ø0.625 HOLES)  
3) WELD INTO PLACE, GRIND FLUSH  
4) DRILL OUT SPACER TO Ø0.484**SECTION BB-BB**  
SCALE 3X, 4 PL

D6-11

D2743  
SPACER

TYP

WELDING INSTRUCTIONS  
1) CHAMFER HOLE 0.050 X 45°  
2) INSERT D2743 SPACER (Ø0.625 HOLES)  
3) WELD INTO PLACE, GRIND FLUSH  
4) DRILL OUT SPACER TO Ø0.484  
5) SPOT FACE Ø0.750 (BOTH SIDES)**SECTION BD-BD**  
SCALE 3X, 4 PL  
(HARDWARE REMOVED FOR CLARITY)

D4-11

D2744  
CAPAFTER FINISH,  
INSTALL  
ALS4-1032-225 INSERT  
AN3C6A BOLT  
AN960C10L WASHER  
NAS1515H3L WASHER  
4 PL

1/16" G

**DETAIL BA**  
SCALE 2X

D8-11

AFTER FINISH,  
INSTALL  
D3492-045  
PLUG ASSEMBLY  
BOTH ENDSD3490-5  
SPACERWELDING INSTRUCTIONS  
1) CHAMFER HOLE 0.050 X 45°  
2) INSERT D3490-5 SPACER (Ø0.313 HOLES)  
3) WELD INTO PLACE, GRIND FLUSH**SECTION BC-BC**  
SCALE 3X, 4 PL

D5-11, C6-11

AFTER FINISH,  
INSTALL  
D3492-041  
PLUG ASSEMBLY  
BOTH ENDSD3490-1  
SPACERWELDING INSTRUCTIONS  
1) CHAMFER HOLE 0.050 X 45°  
2) INSERT D3490-1 SPACER (Ø0.500 HOLES)  
3) WELD INTO PLACE, GRIND FLUSH**SECTION BE-BE**  
SCALE 3X, 4 PL

D4-11, D7-11

DESIGN  
DRAWN  
CHECKED  
MFG. APPR.  
APPROVED  
DE APPR.  
DATE

08.07.16

**DART AEROSPACE USA, INC.**  
PORT HADLOCK, WADRAWING NO.  
**D2750**

REV. F

TITLE  
**350 SKIDTUBE ASSEMBLY**SHEET 11 OF 11  
SCALE  
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**NOTE:** Date & initial all entries

NO. 294

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Barday Elliott  
Job number: 83800  
Part number: A350-636-012  
Description: Skid tube  
Welding Process: Tig ☒ Mig ☐  
Base material: Alum  
Current: AC ☒ DC ☐

TEST REQUIREMENTS AND RESULTS

Visual:

pass ☒ fail ☐

Penetration:

pass ☒ fail ☐

UNACCEPTABLE

Cracks:

pass ☒ fail ☐

Undercut:

pass ☒ fail ☐

Pin holes:

pass ☒ fail ☐

Overlap (cold lap)

pass ☒ fail ☐

Porosity (surface):

pass ☒ fail ☐

Coloration:

pass ☒ fail ☐

Qualifier David Arval

Date of Test Coupon 12.05.09

Welder Barday Elliott

Date of Test Coupon 12.05.09

The above named individual is qualified in accordance with AWS D17.1.2001 to weld